

(C)

PLOT SCALE:

1=1

DWG. SCALE: 1

A2318600

4

3

2

1

D

D

C

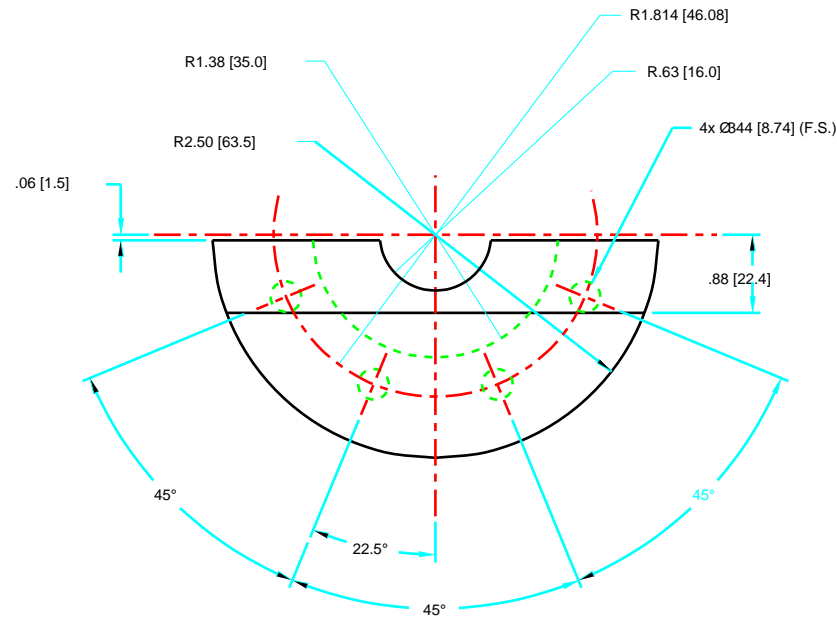
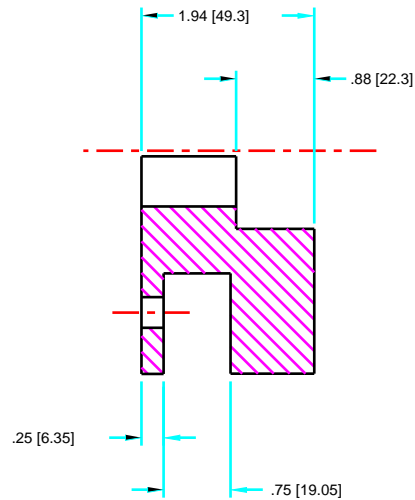
C

B

B

A

A



## NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
2. THIS IS A UHV PART. ELECTROPOLISHING IS NEEDED. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
5. SURFACE ROUGHNESS  $\sqrt{63}$

APPROX. WT. = 3.25 LB.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
<b>PARTS LIST</b>				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGULAR				
.XX - .03				
.XX - .01				
.XXX - .005				
SURFACE ROUGHNESS				
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER <b>A2318600</b>		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
DRAWN BY <b>J.GOGOL</b>	DATE <b>7/24/95</b>	CHIEF DESIGN ENGINEER <b>D.SHU</b>	DATE <b>12/12/95</b>	TITLE <b>ADVANCED PHOTON SOURCE</b>
CHECKED BY <b>J.CHANG</b>	DATE <b>12/7/95</b>	GP LEADER <b>T.M.KUZAY</b>	DATE <b>12/20/95</b>	<b>P9-50 INTEGRAL SHUTTER (E)</b>
DESIGNER <b>J.GOGOL</b>	DATE <b>7/24/95</b>	PROJECT MGR.		<b>COUNTER WEIGHT</b>
RESPONSIBLE ENGINEER <b>J.CHANG</b>	DATE <b>12/7/95</b>	APPROVED/RELEASED		
MATERIAL <b>SST</b>		SCALE 1:1 SIZE C DRAWING NUMBER <b>P4105090909-520003-00</b>		

4

3

2

1